

6061-T6 R.625

Work Order ID 109348

109348

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November-20-13 1:11:06 PM

Item ID: D2808

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Spacer

Start Date: 11/19/13

Start Qty: 60.00

60

Cust Item ID:

Required Date: 11/26/13

Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan: 

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2808

Rev B

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn as per Folio FA256 (Measure D3387 Bracket .507" Dia for Proper press-fit)
2-Deburr

FK 13/11/28

60

Ø

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

FK 13/11/28

60

Ø

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

SA 13-11-28

60

Ø

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Item ID: D2808 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Spacer
 Start Date: 11/19/13 Start Qty: 60.00 *60* Cust Item ID:
 Required Date: 11/26/13 Req'd Qty: 60.00 *60* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130	Hand Finish	0.00							
	Hand Finishing								
140	QC7-Inspect Chemical Conversion Coat	0.00							
140	QC	0.00							
	Quality Control								
150	Identify as per dwg & Stock Location	0.00							
150	Packaging	0.00							
	Packaging								

DAS
26
9-89

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Item ID: D2808

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Spacer

Stop *NS2*

Start Date: 11/19/13 Start Qty: 60.00

60

Cust Item ID:

Required Date: 11/26/13 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

[Handwritten Signature] / BM 13/11/29
mf
13-11-29

Picklist Print

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Parent Item: D2808

Parent Item Name: Spacer

Start Date: 11/19/13

Required Date: 11/26/13

Start Qty: 60.00

Required Qty: 60.00

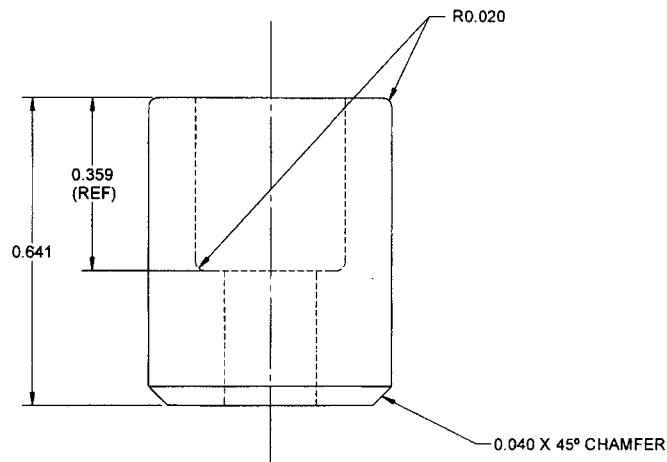
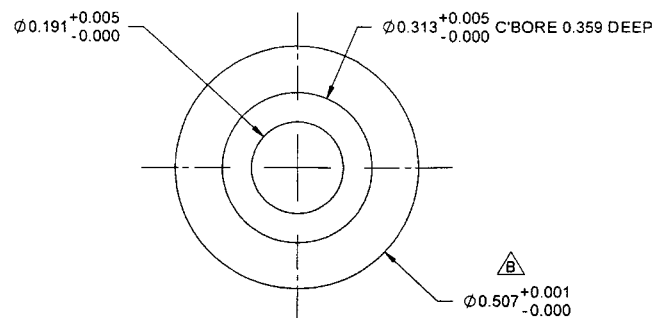
Comments: IPP Rev:D02.03.07Now turned in houseNG
IPP Rev:E 07-12-18 RevB as per dwg ECN1048 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.625 6061-T6 Round Bar .625"		Purchased	No			100	f	78.5720	0.053	4			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT012	78.572	
m126726	78.572	

3.875 ft.

File 13/11/28



Mo 109348

RELEASED
07.10.12

D2808 SPACER

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs

B	REMOVE POWDER COAT: Ø0.507 WAS Ø0.500	DC	07.10.12
A	NEW ISSUE	DS	00.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2808	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SPACER	4:1
DATE	07.10.12	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	